

5/03

W/O SPLIT

DART AEROSPACE LTD	Work Order:	22033B
Description: Bracket	Part Number:	D3264-1
Dwg: D3264 Rev. A	Qty:	15 11
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	04.12.08	15
2	MV	Cut blanks: 4.500" x 1.250" x 5.700" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B1.250x04.500) Identify for D3264-1 Batch: <u>M16391</u>	EP	04.12.16	15 11
3	MV	Machine as per Folio FA447 and Dwg D3264 Identify as D3264-1	9m/EP	04.12.20	11
4	QC2	Inspect parts as they come off the CNC machine	9m/EP	04.12.20	11
5	QC8	Second check	BE	05.03.02	11
6	MV	Deburr	9m	05.02.25	11
7	QC5	Inspect work to Step 6	BE	05.03.02	11
8	FP	Chemical Conversion Coat as per QSI 005 4.1	HL	05.03.03	11
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	HL	05.03.03	11
10	QC3	Inspect Powder Coat	CL	05.03.04	11
11	ST	Identify and Stock <i>Identify with stamp: Batch # using AFINE Print Permanent Marker.</i>	CL	05.03.04	11
12	AC	Cost / part <u>48.99</u>	S45	05.03.08	11
13	DC	Close W/O <u>29.35</u> Inspect Level 21	HA	05.03.08	11

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED  
*[Signature]* 04/09/08

144.78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DART AEROSPACE LTD		Work Order:	22033
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.687	✓		vern	
0.063	+/-0.010	0.061	✓		vern	
0.125	+/-0.010	0.130	✓		mic	
0.875	+/-0.010	0.877	✓		mic	
0.062	+/-0.010	0.068	✓		vern	
R0.03	+/-0.030	0.030	✓		R.g	
R0.13	+/-0.030	0.125	✓		R.g	
1.00	+/-0.030	1.000	✓		mic	
0.125	+/-0.010	0.125	✓		mic	
0.600	+/-0.010	0.601	✓		vern	
R0.38	+/-0.030					cannot find dim
4.000	+/-0.005	4.004	✓		vern	
0.750	+/-0.010	0.754	✓		vern	
<del>0.208</del>	+0.005/-0.000	0.194	✓		vern	
0.194						
5.50	+/-0.030	5.505	✓		vern	
1.27	+/-0.030					cannot find dim
0.125	+/-0.010	0.127	✓		mic	
0.063	+/-0.010	0.067	✓			
R0.25	+/-0.030	0.250	✓		R.g	
4.27	+/-0.030	4.272	✓			
R0.30	+/-0.030	0.30	✓		R.g	

Measured by: <i>EP</i>	Audited by: <i>R</i>	Prototype Approval:	N/A
Date: 04/12/20	Date: 04/12/20	Date:	N/A

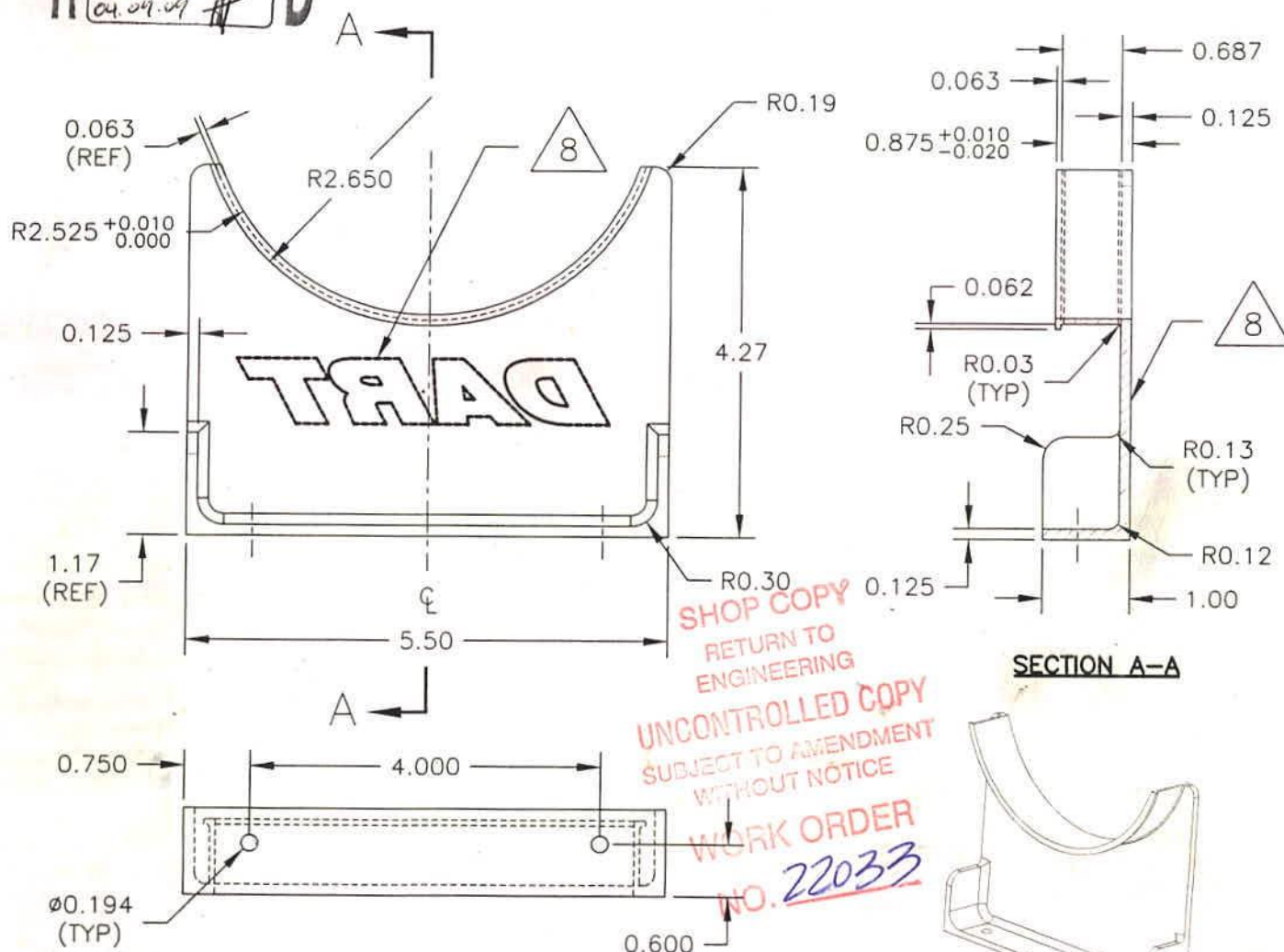
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	<i>[Signature]</i>

**RELEASED**  
04/07/08



DESIGN KT	DRAWN BY KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED  
04.04.09 H



SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22033

### D3264-1 BRACKET

#### D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Dec 06, 2004  
11:09 am

Work Order No : 0022033  
Project Name : D3264-1  
Project For : WK503  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3264-1  
Description : Bracket  
Manufactured : Yes  
Amount Req'd : 15  
Amount Done : 0  
Start Date : 12-03-04  
Est Finish Date : 01-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00